120

QC6- Inspect dimensions to drawing

0.00

\*120\* QC

Memo

Quality Control

									DQA:	Date:	İ	_
NCR: Y	es / No				WORK ORDER NON-C	ONFOR	MANCE / UPD		QA Closed:	Date:		
	· · · · ·		··· ·		DISPOSITION		v. ran	AGAINST DE				ter
Work Orde	er:						[]		•		, , , , , ,	
Part N	lo		···		Rework Scrap Use-as-is		Skid-tube  Machining  noforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor.	Engineering Quality Other	
NCR N	lo				Work Order Update	111011	~ <del> </del>	Composite	1100/3101	Supplier		
Root				Descri	ption of work order update	Initial	Actio	n	Sign &		1	
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Descrip	tion	Date	Verification	QC Inspector	_
Doc/Data												
quip/Tooling											+	
Operator												
Material										,		
Setup		}							,			
Other												
Process										•		
Supplier												
Training [												
Jnapproved [												_
	4		e v .		F	<b>AULT CATE</b>	GORY				1	_
Landir	ng Gear		43.3		General	r			¥ + 3		-	
	Bending				Bend	Grain			Ovalized	<u></u>	Pressure/Forced	
	Centre No	ot Concer	ntric to	o/s	BOM/Route	Hardwa	are		Over/Under	tolerance	Temperature/Cure	
	Cracks				Broken/Damaged .	Inspect	ion Incomplete		Part Incorre	ct <u>'</u>	Weld I	
Ī	Crushed/	Crimped.			Burrs	Instruct	tions Incomplete/Un	clear	Part Lost/M	issing	JWrong Stock Pulled	1
Ī	Cuffs				Contamination	Mainte	enance		Part Moved		1	
Ī	Heat Trea	it			Countersink	Mislabe	eled		Positioned \	Vrong	<u>.</u>	
Ī	Inspection	n Strip in	Tube		Cut Too Short	Misrea	d		Power Loss/	'Surge	Other	

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

140

QC

\*140\*

Quality Control

\*98653\*

0.00

0.00

\*N900040100\*

Page 2

D3183-5 Item ID: Accept **Revision ID:** Bearing Item Name: **Start Qty: 200.00 Start Date:** 3/19/13 Req'd Qty: 200.00 Required Date: 3/22/13 Reference: **Process Plan: Approvals:** Date: Tooling: QC: SPC (Y/N): Date: Sequence 'D/ Operation Set Up/ Work Center ID Description Run Hours Identify as per dwg & Stock Location: 072 3530.00 130 \*120\* 0.00 Packaging Memo Packaging

QC21- Final Inspection - Work Order Release

Memo

**Cust Item ID: Customer:** Run Date: Stop Date: Reject Too! 1D Tool# Plan Accept Reject Qty. Qty Code Number Stamp

Setup Start

13/3/28 8

mr 13-3-21

									DQA:	Date:		
NCR:	res / No				WORK ORDER NON-C	ONFOR	MANCE / UP	DATE	QA Closed:	Date:		
				····	34**		o					
Work Orde	or.				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	i i	
Work Orac					Rework		Skid-tube	Crosstube		Water Jet	Engineerin	g
Part N	No				Scrap		Machining	Small Fab	4	d. Eng. Coor.	Qualit	·
				-	Use-as-is	Ther	moforming	Finishing	Rec/Sto	re/Packaging	Othe	er
NCR N	No				Work Order Update		Large Fab	Composite	]	Supplier	1	
Root				Descri	ption of work order update	Initial	Ac	ction	Sign &			er i veriller
Cause	Date	Step	Qty	(	or Non-conformance	Chief En	g Desc	ription	Date	Verification	QC Inspe	ector
Doc/Data										-		
Equip/Tooling												
Operator		ĺ										
Material			İ									
Setup			Ì			İ						
Other												
Process												
Supplier											1:	
Training												
Unapproved	<u></u>	<u> </u>				<u> </u>						
						AULT CAT	EGORY					
Landi	ng Gear				General			<u> </u>	7		ار ا	
	Bending				Bend	Grain			Ovalized	, <u> </u>	Pressure/For	
	Centre No	ot Concer	ntric to	o/s	BOM/Route	Hardv		ļ	Over/Under	<del></del>	Temperature	e/Cure
	Cracks				Broken/Damaged	<b></b>	tion Incomplete	<u></u>	Part Incorre	<del> </del>	Weld	0 11- 1
	Crushed/	Crimped.			Burrs	${f m{arphi}}$	ctions Incomplete,	/Unclear	Part Lost/M	_	Wrong Stock	Pulled
	Cuffs			<u> </u>	Contamination		tenance	<u> </u>	Part Moved			
	Heat Trea	it		<u> </u>	Countersink	Mislal		<u> </u>	Positioned \		┪╴	
	Inspection	n Strin in	Tube		Cut Too Short	Misre	ad		Power Loss	/Surge	Other	

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence
Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

# **₹** Picklist Print

March 19, 2013 12:56:08 PM

Work Order ID:

98653

Parent Item:

D3183-5

Parent Item Name:

Bearing

**Start Date: 3/19/13** 

Required Date: 3/22/13

Start Qty: 200.00

Required Qty: 200.00

Comments:

Bearing

IPP: A03.03.27New issueKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
6800ZZ		Purchased	No			100	Each	0.0000	1	200			

/13/3/26 (200)

Page 1

									DQA:	Date	:	
NCR: \	Yes / No				WORK ORDER NON-C	ONFOR	MANCE / UPDA		QA Closed:	Date	. !	
Work Orde	er:		· · · · · · · · · · · · · · · · · · ·		DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	;	
Part N					Rework Scrap Use-as-is	Ther	Machining :	Crosstube Small Fab Finishing	1	Water Jet d. Eng. Coor. re/Packaging	Engineerir Quali Othe	ty 🗌
NCR N	No				Work Order Update		Large Fab C	omposite		Supplier		
Root					ption of work order update	Initial	Action		Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	g Descripti	ion	Date	Verification	QC Insp	ector
Doc/Data									1.5			
Equip/Tooling									- x <sup>2</sup> ···			
Operator							137					
Material									:			
Setup												
Other						ł						
Process												
Supplier		1										
Training											1	
Unapproved		<u> </u>	1			AULT CAT	ECORY			<u> </u>		
Landie	ng Gear			<u>-</u>	General	AUL! CAT	EGONT	<u> </u>			+	
Lanun	Bending				Bend	Grain			Ovalized	Γ	Pressure/For	rced
	Centre No	nt Concer	ntric to C	1/5	BOM/Route	Hardw	rare		Over/Under	tolerance	Temperature	
	Cracks	or concer	tille to c	″³  -	Broken/Damaged	<b>——</b>	tion Incomplete	}	Part Incorre	<b>⊢</b>	Weld	c, ca. c
	Crushed/	Crimned		-	Burrs	$\vdash$	ctions Incomplete/Uncl	lear	Part Lost/M	<b> </b>	Wrong Stock	c Pulled
	Cuffs	cinipeu,		<u> </u>	Contamination	<b></b>	cenance	-	Part Moved			
}	Heat Trea	ıt.			Countersink	Mislab			Positioned \			
	Inspection		Tube		Cut Too Short	Misrea			Power Loss/		Other	
	Ripples in				Drill Holes	Offset		<u> </u>	J,	~ L	1	
	Torque W		xtrusion	,	Drawing		Calibration					

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

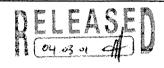
Finish

Folio





DESIGN	#-	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CA	
CHECK	ED	APPROVED	DRAWING NO.	REV. C
	#	4	D3183	SHEET 1 OF 4
DATE			TITLE	SCALE
1	04.0	)2.17	BRACKET ASSEMBLY	1:1
Α	0:	3.01.24	NEW ISSUE	



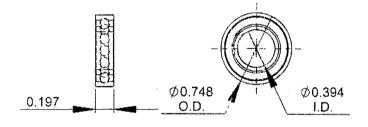
DEO ATTACHED

DAIL		IIILE	SCA
1	04.02.17	BRACKET ASSEMBLY	
A	03.01.24	NEW ISSUE	
В	03.06.17	REMOVE BEARING; 1.012 WS 0.882	
С	,04.02.17	ADD -045/-9; 0.182 WAS 0.431	
<u>Cı</u>	***************************************	0.830 WAS 0.850	
	A B C	04.02.17 A 03.01.24 B 03.06.17 C 04.02.17	04.02.17       BRACKET ASSEMBLY         A       03.01.24       NEW ISSUE         B       03.06.17       REMOVE BEARING; 1.012 WS 0.882         C       .04.02.17       ADD -045/-9; 0.182 WAS 0.431         C1       -432 04.10.03       0.830 was 0.850

D3121-21 BOLT (1) D3183-045 BEARING ASSEMBLY (1)

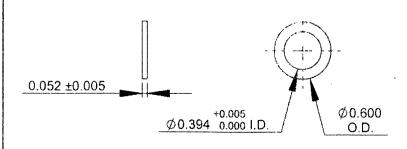
D3121-21 BOLT (1) D3183-045 BEARING ASSEMBLY (1) D3183-1 BRACKET FOR -041 (SHOWN) D3183-2 BRACKET FOR -042 (OPPOSITE) OR D3183-3 BRACKET FOR -043 (SIMILAR) OR D3183-4 BRACKET FOR -044 (SIMILAR) Cd 13/03/19 W101, 98653

> D3183-041 ERACKET ASSEMBLY (SHOWN)
> D3183-042 ERACKET ASSEMBLY (OPPOSITE)
> D3183-043 ERACKET ASSEMBLY (SIMILAR) D3183-044 BRACKET ASSEMBLY (SIMILAR)



### **D3183-5 BEARING:** SPECIFICATION CONTROL DRAWING

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
  2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES



## **D3183-7 WASHER**

- 1) MATERIAL: AISI 303 ROUND BAR (M303R) **ANNEALED**
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

#### COPYRIGHT @ 2003 BY DART AEROSPACE LTD.



Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7

Tel: 613 632 9577 Fax: 613 632 1053

#### **PURCHASE ORDER**

#### Purchase Order ID PO19373

Purchase Order Date 3/19/13 PO Print Date 3/19/13

Page Number 1 of 1

Order From:

VC-MAI001

MAIN INDUSTRIAL SALES LTD.

1475, TESSIER

HAWKESBURY, ON K6A 3S6

CA

Contact Name

Vendor Phone

613 632 3595

Vendor Fax

613 632 0262

Vendor Account Nbr

Buyer

Requisition Nbr

Tax Resale Nbr

**Terms** Currency

CAD

**FOB** 

Net 30

Destination-Collect

Chantal Lavoie

10127-2607

Ship To:

DART AEROSPACE LTD

1270 ABERDEEN

HAWKESBURY, ON K6A 1K7

**CANADA** 

Line Nor Reference

Revision ID

Description/ Mfg ID

Req Date/ Taxable Unit of Measure

Req Qty/

Each

Ship Method Unit Price Extended

Price

Vender Part Number

6800ZZ

Bearing

3/20/13

Yes

200.00 Yours ppd

\$1.4800

\$296.00

Special Inst

AS PER DWG D3183 REV. C

SINGLE ROW, DEEP GROOVE, CONRA TYPE,

NSK P/N: 6800ZZ

PO Total:

\$296.00

CERTIFICATE OF CONFORMITY REQ'D UPON DELIVERY

No substitution or deviation without consent.

Certificate of Conformity or Material Certification required -{YES NO

Change Nbr:

Change Date: 3/19/13

# MAIN INDUSTRIAL SALES LTD.

1475 TESSIER ST.

HAWKESBURY ON K6A 3S6 Phone: (613) 632-3595 Ext. Fax: (613) 632-0262

sales@mainindustrialsales.com

Packing Slip.

**DATE** March 19, 2013 **NUMBER** 0000161101 **CUSTOMER NO. DART** 

BILL TO:

DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY ON K6A 1K7 SHIP TO:

DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY ON K6A 1K7

(613) 632-5200 Ext.

(613) 632-5200 Ext.

P.O.	NUMBER	SALESPERSON	ORDER DATE	REQ. DATE	ORDER NUMBER
	19373	EB	19-Mar-13		0000161101
	F.O.B.	SHIP VIA		TERM	S
F.(	D.B. value	PICK UP		NET 30 D.	AYS
PART NUMB	ER				NTITY
DESCRIPT	ION	LOCATION	UOM	REQ. SH	IPPED B.O.
0-68002ZKML BALL BEARIN	lG	6D6	EA	200 1	54
YOUR PART	#: 6800ZZ	معمد الدعيية والدعار والمعمل إيلامهمينايي بدريماني الأساس يتمسعون	The second secon	named the grant the control of the c	
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					<b>,</b> 19
:	•				\$ ** *
		:		. 1	

# MAIN INDUSTRIAL SALES LTD.

1475 TESSIER ST.

BILL TO:

HAWKESBURY ON K6A 3S6

Phone: (613) 632-3595 Ext. Fax: (613) 632-0262

sales@mainindustrialsales.com

DART AEROSPACE LTD.

HAWKESBURY ON K6A 1K7

1270 ABERDEEN ST.

Packing Slip

**DATE** March 22, 2013 NUMBER 0000161101 **CUSTOMER NO. DART** 

SHIP TO:

DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY ON K6A 1K7

(613) 682-5200 Ext

19373         EB         19-Mar-13         00001617           F.O.B.         SHIP VIA         TERMS           F.O.B. value         PICK UP         NET 30 DAYS           PART NUMBER         QUANTITY	(613) 6	B2-5200 Ext.		(613) 632-5200 Ext.						
F.O.B. SHIP VIA TERMS  F.O.B. value PICK UP NET 30 DAYS  PART NUMBER DESCRIPTION LOCATION UOM REQ. SHIPPED B.  0-68002ZKML BALL BEARING	P.O.	NUMBER	SALESPERSON	ORDER DATE	REQ. DATE	ORDER NUMBER				
PART NUMBER DESCRIPTION LOCATION UOM REQ. SHIPPED B. 0-68002ZKML BALL BEARING		19373	EB	19-Mar-13		0000161101				
PART NUMBER DESCRIPTION LOCATION UOM REQ. SHIPPED B. 0-68002ZKML BALL BEARING		.О.В.	SHIP VIA	<u> </u>	TERM	IS				
DESCRIPTION LOCATION UOM REQ. SHIPPED B. 0-68002ZKML 6D6 EA 54 54 BALL BEARING	F.C	.B. value	PICK UP		NET 30 D	AYS				
0-68002ZKML 6D6 EA 54 54 BALL BEARING	PART NUMB	ER	:		QUA	NTITY				
BALL BEARING	DESCRIPT	ION	LOCATION	UOM	REQ. SH	IIPPED B.O.				
YOUR PART *: 6800ZZ		G	6D6	EA	54	54				
	YOUR PART	#: 6800ZZ	and the second transfer of the second of the		, - <u></u>	and the second second second				
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